

Wednesday, July 08, 2015 3:07:03 PM

134279

Page 1

Item ID: D3023-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Back Panel

Stop ***NS2***

Start Date: 7/18/15 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 7/18/15 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: _____ **Process Plan:** MLS **Date:** JUL 09 2015 **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3023	B

100

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3023

Dwg Rev: B

Prog Rev: B

***graind direction along 28.100" ***

2-Deburr if necessary

0.00

0.01

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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Item Name: Back Panel
Start Date: 7/18/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/18/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				DAS 38 9-89			DAS 38 9-89 JUL 30 2015
130 *130* Brake NC Brake NC	Form as per dwg Memo	0.00 0.00				DAS 30 9-89	(		JUL 30 2015
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				DAS 38 9-89			DAS 38 9-89 AUG 04 2015

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Work Order update only ☐

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2 0 1 5 0 8 0 4

5A

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Picklist Print

Wednesday, July 08, 2015 3:07:01 PM

Page 1

Work Order ID: 134279

134279

Parent Item: D3023-1

D3023-1

Parent Item Name: Back Panel

Start Date: 7/18/15

Required Date: 7/18/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C02.01.23Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased		No		100	sf	43.9060	2.8777	4			

M2024T3S 032

2024-T3 .032 sheet

DC 15/07/30

Location

Loc Qty

Loc Code

MAT022

43.906

M130497

43.906

132875

6.2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
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DART AEROSPACE LTD		Work Order:	134279
Description: Back Panel		Part Number:	D3023-1
Inspection Dwg: D3023	Rev: <i>B</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	Ø.130	/		V-D-02	
Ø0.191	+0.005/-0.001	Ø.192	/		Tape	
1.660	+/-0.010	1.663	/		V-D-01	
0.375	+/-0.010	.380	/			
1.340	+/-0.010	1.345	/			
2.375	+/-0.010	2.379	/			
0.375	+/-0.010	.379	/			
25.28	+/-0.030	25.28	/			
27.03	+/-0.030	27.03	/			
28.10	+/-0.030	28.10	/			
1.30	+/-0.030	1.30	/			
2.375	+/-0.010	2.380	/			
8.711	+/-0.010	8.715	/			
5.597	+/-0.010	5.599	/			
8.57	+/-0.030	8.57	/			
1.970	+/-0.010	1.973	/			
7.42	+/-0.030	7.42	/			
10.92	+/-0.030	10.92	/			
14.75	+/-0.030	14.75	/			

Measured by: <i>D</i>	Audited by: <i>DAS</i> 38	Prototype Approval:	N/A
Date: 15/7/30	Date: JUL 30 2015	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC <i>A</i>	<i>D</i>

R0.38
TYP

0.22

JOGGLE ON THIS
SIDE WHERE
SHOWN

Technical drawing of a mechanical part, likely a bracket or support, showing dimensions and tolerances. The part has a vertical central section and two angled sections. Dimensions include a vertical distance of 0.19, a horizontal distance of 0.10, and an angle of 50° TO 70°. A tolerance of R0.10 is indicated on the angled surface.

Technical drawing of a vertical component. The drawing shows a vertical line with a horizontal line intersecting it. The vertical distance from the horizontal line to the top is labeled 22.05. The horizontal line is labeled R4.8. The angle between the vertical line and a diagonal line is labeled 15°.

Technical drawing of a rectangular duct with rounded corners and a central vertical support. The drawing includes dimensions for plate thickness (4 PL), radii (R0.191, R4.50, R0.88), and various offsets (1.970, 1.30, 0.375, etc.). Section lines A-A and B-B are indicated.

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 2.4 lbs

SECRET
 EYES ONLY
 UNCONFIDENTIAL
 SUBJECT TO ADMINOMONY
 WITHOUT NOTICE
 ORDER

2015 FEB 04
ECN 15-522 *9*

B	UPDATED FORMAT. POWDER COAT REMOVED TO BE APPLIED AT NEXT ASSEMBLY.		AJS	14.11.13
A	NEW ISSUE		CP	01.05.18
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3023 TITLE BACK PANEL	REV. B	
DRAWN	AJS		SHEET 1 OF 1	
CHECKED			SCALE	
MFG. APPR.			NTS	
APPROVED				
DE APPR.		DATE 14.11.13 COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		